



7210

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW1205G00332-3G

Job Sheet 186409

8014
Nov 30

Part No: RBW1205G00332-3G

Job Qty: 1 ea 2

Part Name: Main Gear Box Oil Draining Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	1 pcs	12/7/18	12/7/18	0.00	1.33	Small Fab-9		MLC DAS
110	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		30
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		DEC 27 2018 9:39 GA
140	QC21-FG	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		DEC 27 2018 7:00

Part Op 100 - 1-Cut 9657k135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1. Install a 1.0" long
Descriptions: 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the
Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1315	Crimp Hose Clamp 9/16"	1 pcs (1 ea)	90-Start up Operation	5042369
2619	Spring Rnd 3/4"	1 Ea (1 ea)	90-Start up Operation	5075045
4464T123	O-Ring 9/16 Od X 1/16 Cross	1 Ea (1 ea)	90-Start up Operation	5048577
91665A350	Retaining Ring, 7/16" Shaft	1 Ea (1 ea)	90-Start up Operation	5046069
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	90-Start up Operation	5127046
RBW1205G00332-3G-01	Cap	1 Ea (1 ea)	90-Start up Operation	5061879
RBW1205G00332-3G-03	Quill	1 Ea (1 ea)	90-Start up Operation	5139008
RBW1205G00332-3G-17	Sleeve	1 Ea (1 ea)	90-Start up Operation	5136972
RBW1205G00332-3G-19	Barb	1 Ea (1 ea)	90-Start up Operation	5110398
RBW1205G00332-3G-21	Valve	1 Ea (1 ea)	90-Start up Operation	5137144
RBW1205G00332-3G-23	Screw (Modified B/O)	2 Ea (2 ea)	90-Start up Operation	5112421
RBW1205G00332-3G-24	End Cap	1 Ea (1 ea)	90-Start up Operation	5062111
9657K135	Spring	1 Ea (1 ea)	90-Start up Operation	5047612
M304TR0.375W.065	304 Round Tube .375 X .065W	.0830 ft (.083 ea)	100-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	1315	1	54	0
	2619	1	47	0
	4464T123	1	47	0
	91665A350	1	25	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

100-Small Fab

9657K135	1	20	0
K010-0608	6	419	0
RBW1205G00332-3G-01	1	3	0
RBW1205G00332-3G-03	1	0	0
RBW1205G00332-3G-17	1	0	0
RBW1205G00332-3G-19	1	18	0
RBW1205G00332-3G-21	1	0	0
RBW1205G00332-3G-23	2	12	0
RBW1205G00332-3G-24	1	3	0
M304TR0.375W.065	0	20	0

Part Specifications

Specifications could not be found.

Plex 11/15/18 10:05 AM Dart.lajeunesse.marie



Container No: S140167



Part: RBW1205G00332-3G

Job No: 186409

Serial No/Batch: S140167

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/24/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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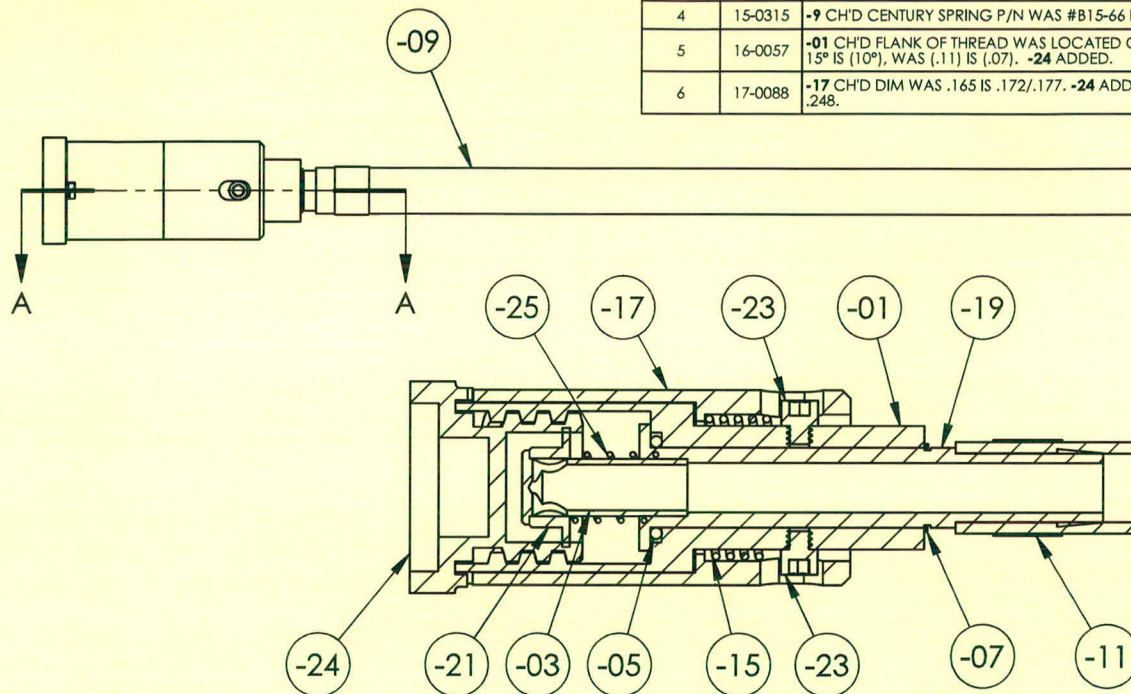
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Description Work Order Deviation 	Disposition 	Completed By
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135 - .3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (10°), WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC JAG



SECTION A-A
SCALE 1 : 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186409/PL5-
1871-1

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	CAP	6061		2
			-03	1	QUILL	303/304 S.S.		3
		B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
		B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
		B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
		B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
		B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
			-17	1	SLEEVE	6061		4
			-19	1	BARB	303/304 S.S.		5
			-21	1	VALVE	303/304 S.S.		6
			-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
			-24	1	END CAP	6061		8
		B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENG RIED #S1165	1

DART
AEROSPACE

TITLE
MAIN GEAR BOX DRAIN TOOL

DWG NO. RBW1205G00332-3G REV 6

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AGUSTA
SCALE 1:2	DATE 2/23/2011
	SHEET 1 OF 8

